

Date: Wednesday, 9/6/2006 3:45:35 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG BRACKET	
Job Number	: 28440		Part Number	: D30461	
Estimate Number	: 10733		Drawing Number	: D3046 REV A <i>UNDER REVIEW</i>	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 9/6/2006 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 9/13/2006 Qty: 10 Um: Each	
Previous Run	: 27196				
Written By	:				
Checked & Approved By	:				
Comment	: Est A 0108.27 New Issue SM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S12GA	1010/1025/A21/6aA SHEET
Comment: Qty.: 0.1260 sf(s)/Unit Total: 0.7560 sf(s) 1010/1025/A21/6aA SHEET Batch: <i>MESES M1010S12GA</i> <i>M 06 09 07</i>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3046 Dwg Rev: <i>A</i> Prog Rev: <i>A</i> <i>M 06 09 07</i>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>M 06 09 07</i>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <i>J 06 09 07</i>		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Tumble & deburr Bend as per dwg D3046 <i>S 06 09 07</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/09/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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Job 06-09-07(10)



Comment: INSPECT WORK TO CURRENT STEP

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 09 08

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/09/11

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G A

SB 06/09/11

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

SB 06/09/11

Job Completion



U 06/09/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

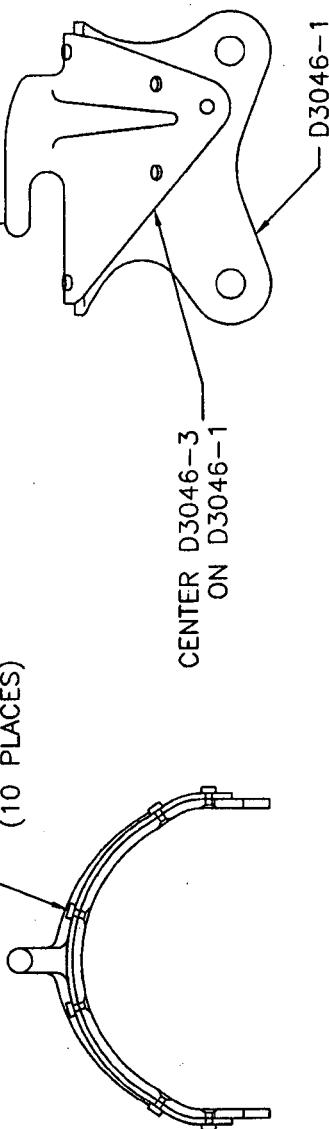
NOTE: Date & initial all entries

DARTCOPY IS
MADE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3046	SHEET 1 OF 2
DATE	TITLE		SCALE
01.08.23	LUG BRACKET		1:2
A	01.08.23	NEW ISSUE	

D3046-3
(BELL P/N 206-052-106-1)

TRANSFER DRILL \varnothing 0.156 HOLES
FROM D3046-3 TO D3046-1.
C SINK \varnothing 0.286 x 100°.
D3046-1 INSIDE BORE.
ASSEMBLE USING MS20426AD5-7
RIVETS.
(10 PLACES)



D3046-041 LUG BRACKET ASSEMBLY

UNDER REVIEW

06.00.02
CHANGING TO WELDED
DESIGN

RELEASED

01.08.23

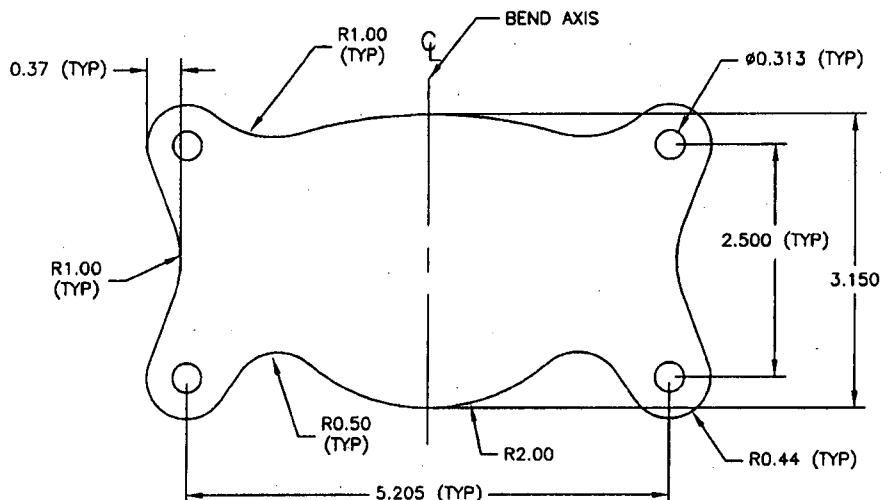
NOTES:
 1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
 POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.
 RE-POWDER AFTER ASSEMBLY.
 REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.
 1) SHO^N COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 28440

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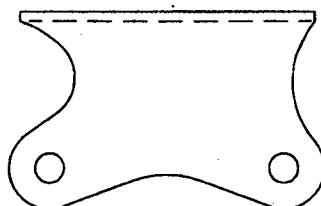
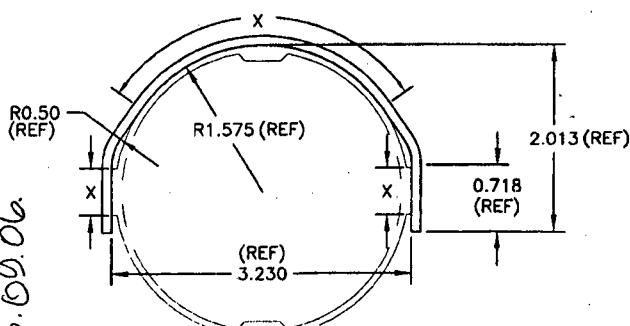
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE	01.08.23	D3046	SHEET 2 OF 2
		TITLE	SCALE
		LUG BRACKET	1:2



D3046-11 FLAT PATTERN
SYMMETRICAL ABOUT CENTRE-LINES (Q)



D3046-1
(MAKE FROM D3046-11)

D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE
OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

UNDER REVIEW
06.09.06

GENERAL NOTES
MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28440

RELEASED
01.08.23

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DART AEROSPACE LTD

Work Order: 28440

Description:

Part Number: 3046-1

Inspection Dwg:

;Rev:

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article

x Prototype

Measured by:

Date: 06.09.07

Audited by:

Date: 060907

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	